

5/25

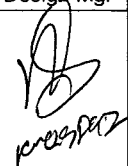
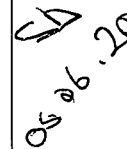
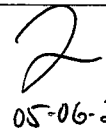
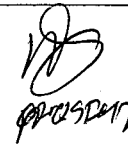
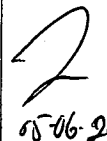
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23578
<b>Description:</b> Step Leg		<b>Part Number:</b>	D3077-1
RF 03.02.28 RF 03.02.28			D3170-1
Dwg: D3077 Rev. A1 A2 D3170 Rev. A		<b>Qty:</b>	30 40
RF 03.02.17			Page 1 of 1
			Stack of 10


Step	Location	Procedure	By	Date	Qty	
1	DC	Issue Traveller	HJ	05.06.16	30	46
2	MV	Cut blanks: 12.100" x 5.070" (+0.030/-0.000) Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch: M17695 Identify as D3077-1	SA	05.06.18	30	40
3	MV	Cut blanks: 11.990" x 0.750" (-0.00/+0.010) Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch: M17124 Identify as D3170-1	SA	05.06.18	30	40
4	MV	Machine per Folio FA284 and Dwg D3077	SA	05.06.19	40	
5	QC2	Inspect parts as they come off the CNC machine	SA	05.06.19	40	
6	MV	Deburr to take measurement	SA	05.06.19	40	
7	QC8	Second inspection	FE	05.06.19	40	
8	MV	Machine per Folio FA282 and Dwg D3170	SA	05.06.19	40	37 P10
9	QC2	Inspect parts as they come off the CNC machine	SA	05.06.19	40	37
10	MV	Deburr to take measurement	SA	05.06.19	40	37
11	QC8 & 5	Second inspection	FE	05.06.20	40	37
12	GA	Deburr D3077-1 and D3170-1 stack 40 FF 37 FF	FF	05.06.22	37/40	
13	FP	Acid etch and Alodine per QSI 005 4.1 D3077-1 and D3170-1	FF	05.06.22	37/40	
14	QC5	Inspect work to Step 13	SA	05.06.23	37/40	
15	GA	Identify and Stock D3077-1 and D3170-1	SA	05.06.23	37/40	
16	AC	Cost / part 1.96 3.66	SA	05.06.24	37/40	
17	DC	Close W/O 5.93 3.66 Inspect Level 21	HJ	05/07/05	37	

Rev	Date	Change	Revised By	Approved
A	02.10.11	New issue	KJ	
B	02.11.18	Incorporated D3170-1 IPP	KJ RF	

RELEASED  
02-11-20 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-20	8	3 x 3170-1 spacer scrap to deep of scratches on the material		Scrap: destroy	 05-06-20	 05-06-20		 05-06-20

Part No: D3077-1/D3170-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 05/07/05

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

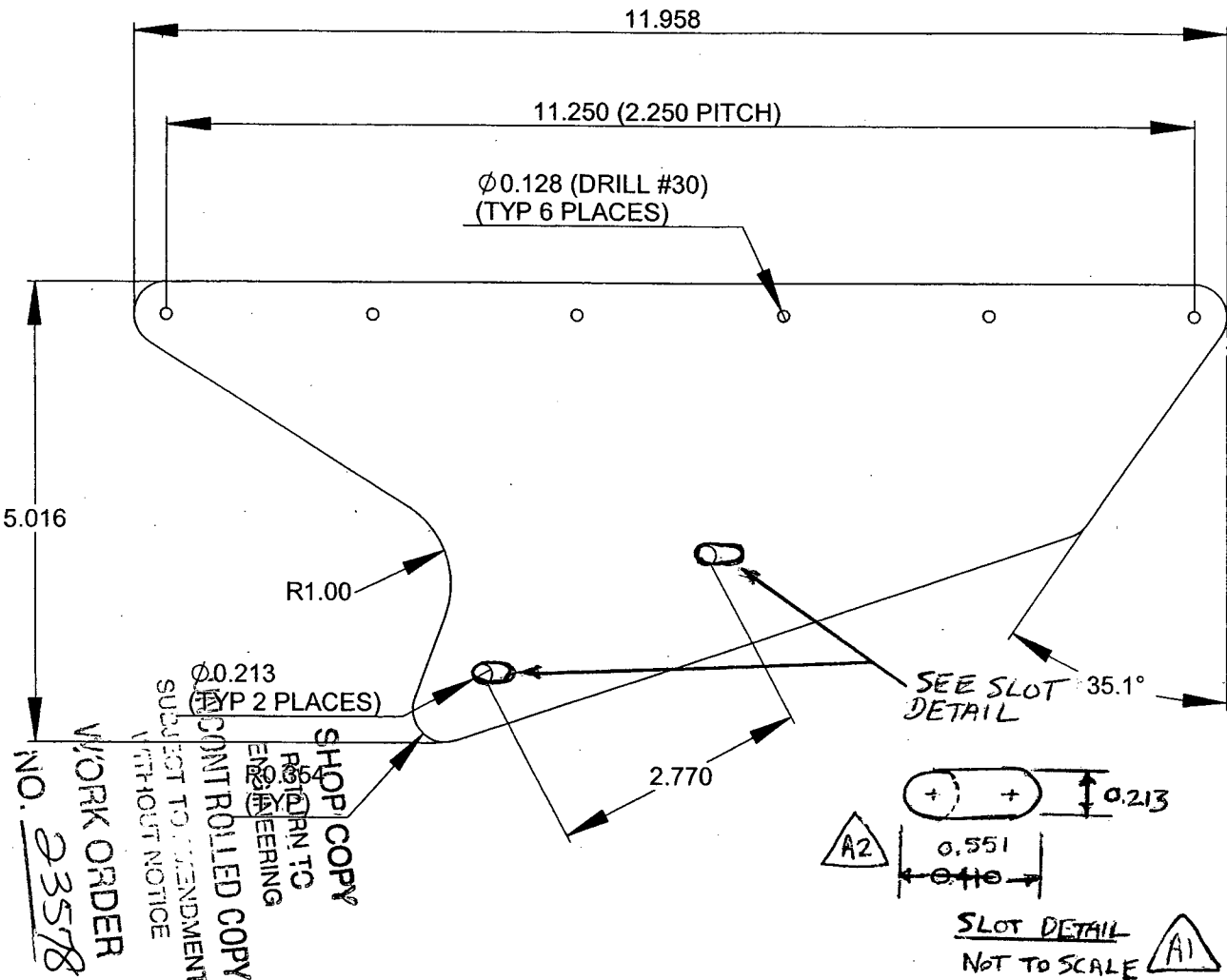






RELEASED  
02.09.2011

DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	[Signature]	APPROVED	[Signature]	REV. A
DATE	02.09.11	DRAWING NO.	D3077	SHEET 1 OF 1
		TITLE	STEP LEG	SCALE 1:2
A	02.09.11	NEW ISSUE		
A1	03.02.13	ADD SLOTS		
A2	03.02.27	0.551 WAS 0.410		



### D3077-1 STEP LEG

- 1) MACHINE PER DWG FILE "D3077-1.SLDPRJT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

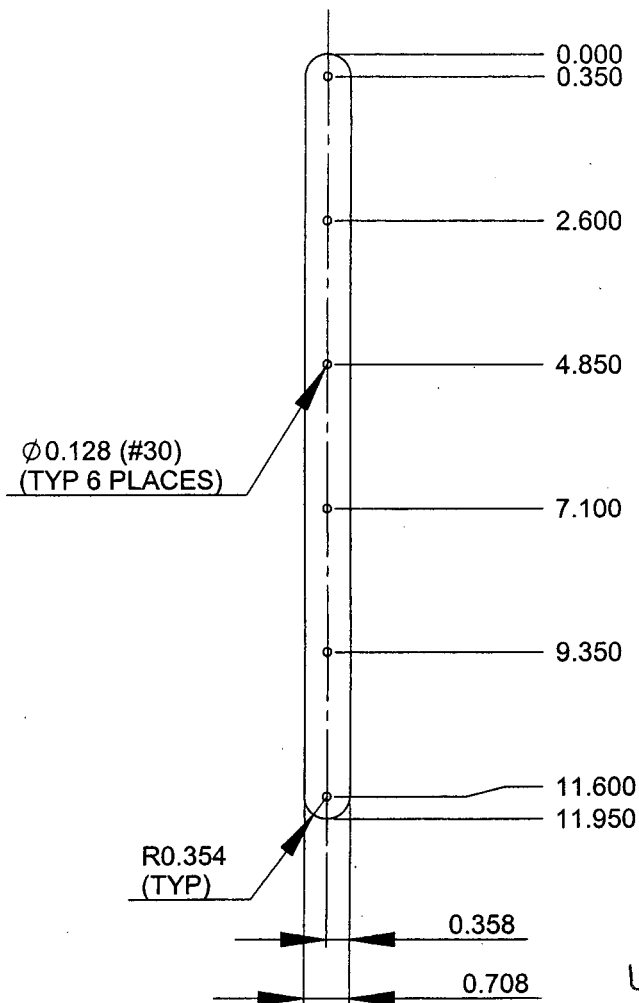
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3170</b>	REV. A SHEET 1 OF 1
DATE <b>02.09.11</b>		TITLE <b>SPACER</b>	SCALE 1:3
A	02.09.11	NEW ISSUE	

**RELEASED**  
02.09.20 *[Signature]*



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**WORK ORDER**  
NO. 23518

### **D3170-1 SPACER**

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 16, 2005  
08:04 am

Work Order No : 0023578  
Project Name : D3077-1  
Project For : WK525  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3077-1  
Description : Step Leg  
Manufactured : Yes  
Amount Req'd : 30  
Amount Done : 0  
Start Date : 06-15-05  
Est Finish Date : 06-24-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark'Up : 0.000%  
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00